

Work Order ID 161473

161473

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Tuesday, May 16, 2017 1:07:02 PM

Item ID: D4021-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Plate
 Start Date: 5/23/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 5/24/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAY 16 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4021	B

100 0.00

100

Waterjet
FLOW CNC Waterjet

Memo
Cut as per dwg D4021
Prog Rev: 
Dwg Rev: 
Deburr as required

1.67

 SC 17/05/19

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC
Quality Control

Memo

0.40

 DAS 38 9-88 / SC 17/05/19

Work Order ID 161473

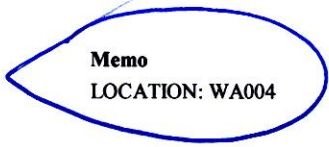
Tuesday, May 16, 2017 1:07:02 PM

161473

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.80				<u>42</u>			<u>PD</u> MAY 23 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo LOCATION: WA004	0.00 0.40				<u>42</u>			<u>MAY 24 2017</u> DAS 6 9-88
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 4.00							<u>175/254</u>  MAY 24 2017

Picklist Print

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Work Order ID: 161473

161473

Parent Item: D4021-1

D4021-1

Parent Item Name: Handle Plate

Start Date: 5/23/2017

Required Date: 5/24/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

45.9830

0.1225

5.157895

M304S11GA

**

304/316 0.125 Sheet

sc 17/05/19

Location

Loc Qty

Loc Code

MAT020

45.983

M137110

26.2

M137263

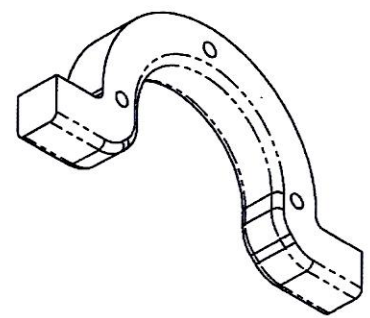
19.783

5.2

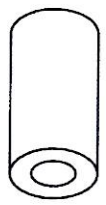
DATE		10.04.06	
DESIGN	AJS	CHECKED	JPH
DRAWN	JPH	MFG. APPR.	[Signature]
APPROVED	[Signature]	DE APPR.	[Signature]
TITLE		MISC PARTS - 350 BASKET	
DRAWING NO.		D4021	
REV. B		SHEET 1 OF 3	
DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DESCRIPTION		POWDER COAT SPEC ADDED TO NOTE 2 (A&Z)	
REV.	A	NEW ISSUE	
DATE	10.04.06	BY	JPH
DATE	10.01.29	BY	JPH

NO. MAY 16 2017
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENTS
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY
 RELEASED
 2010-04-14

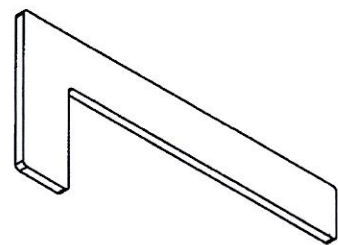
D4021-7 HOOP



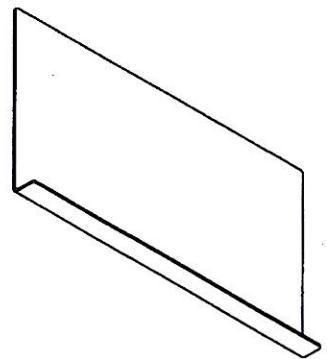
D4021-9 BUSHING



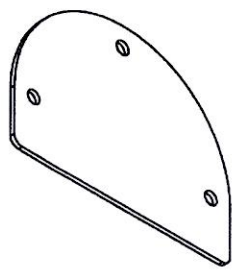
D4021-1 HANDLE PLATE



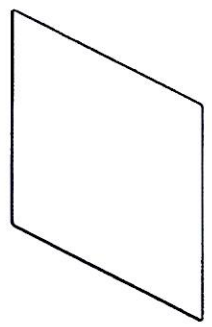
D4021-3 DATA PLATE

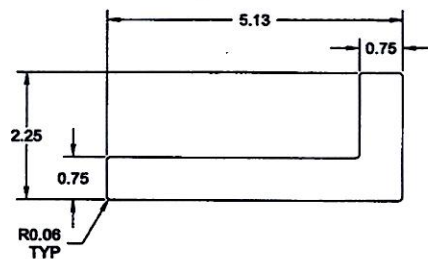


D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE

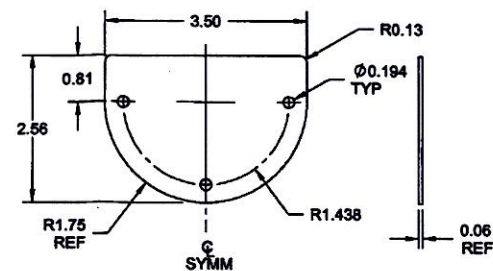




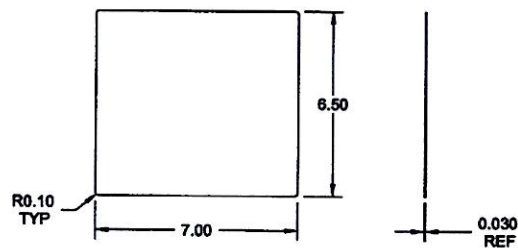
D4021-1 HANDLE PLATE



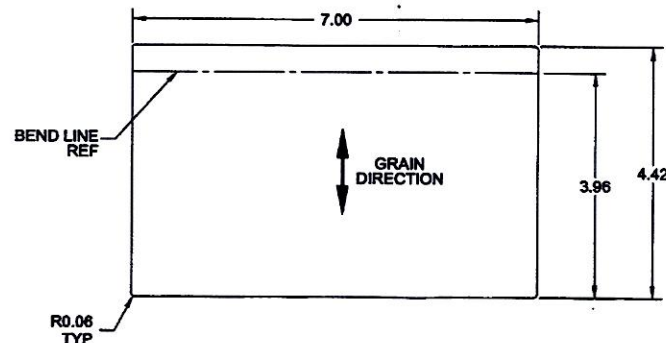
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
2010-04-14
NIP

NOTES:

1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S16GA OR M304S16GA

-11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S22GA

2) FINISH: -1/-3/-11: NONE

-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

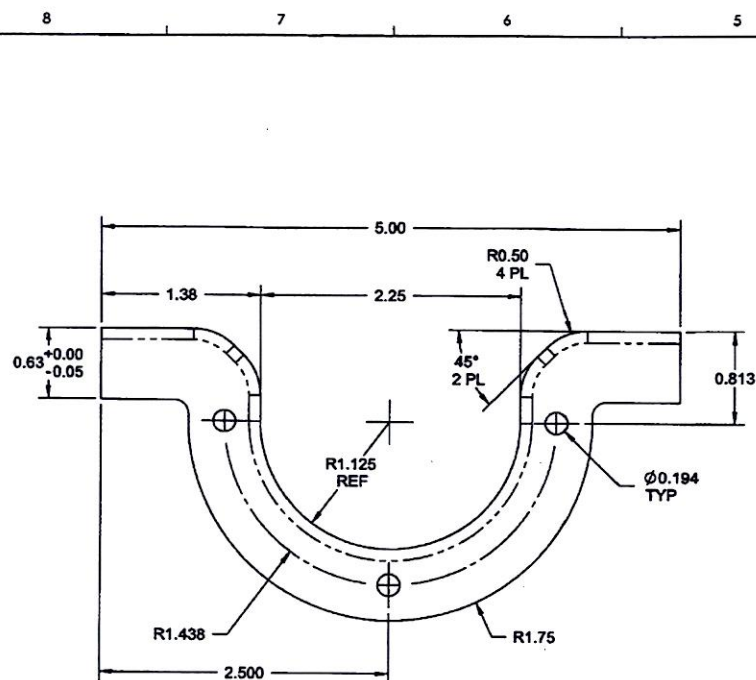
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

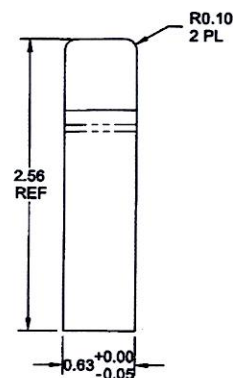
7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs

-5: 0.14 lbs -11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4021-7 HOOP



D4021-9 BUSHING

RELEASED
2010-04-14
NR

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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